

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011434**Date Inspected:** 13-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet (Document No. 005051):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

- | | |
|-------------------------|-------------------------|
| 1. 13TB11 weld 001, 002 | 2. 13TB16 weld 001, 002 |
| 3. 13TB20 weld 001, 002 | 4. 13TB25 weld 001, 002 |
| 5. 13TB26 weld 001, 002 | 6. 13TB30 weld 001, 002 |
| 7. 13TB41 weld 001, 002 | 8. 13TB52 weld 001, 002 |

Magnetic Particle Testing (MT) pursuant to NDT Inspection Notification Sheet (Document No. 005051):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

- | | |
|-------------------------|-------------------------|
| 1. 13TB11 weld 001, 002 | 2. 13TB16 weld 001, 002 |
| 3. 13TB20 weld 001, 002 | 4. 13TB25 weld 001, 002 |
| 5. 13TB26 weld 001, 002 | 6. 13TB30 weld 001, 002 |
| 7. 13TB41 weld 001, 002 | 8. 13TB52 weld 001, 002 |

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 20TR1-009; Weld 001, 005, 003. Welder is identified as 045209 and 062708. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-010; Weld 001. Welder is identified as 045209 and 062708. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-0011; Weld 005 and 007. Welder is identified as 058245 and 045227. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-012; Weld 005. Welder is identified as 058245 and 045227. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-007; Weld 005. Welder is identified as 207465. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Holmes, Stefan

Quality Assurance Inspector

Reviewed By: Hall, Steven

QA Reviewer